COMMERCIAL STANDARD CS208-57

Standard Stock Exterior Wood Window and Door Frames

A recorded voluntary standard of the trade published by the U. S. Department of Commerce

Standard Stock Exterior Wood Window and Door Frames

[Effective February 1, 1957]

1. PURPOSE

1.1 The purpose of this Commercial Standard is to establish standard designs, sizes, and specifications for standard stock wood window, sash, and door frames; to guide producers, distributors, architects, builders, and the public; to provide the building industry with standard wood window and door frames; to avoid delays and misunderstandings; and to effect economies from the producer to the ultimate user through a wider utilization of these wood window and door frames.

1.2 In the development of this standard every effort has been made to include designs that will permit freedom of architectural expression. Custom-made frames and proprietary frames as parts of units will continue to be available for all types of architectural designing.

2. SCOPE

2.1 This standard provides minimum specifications for standard stock wood exterior window and sash frames and exterior door frames. It covers construction, grading, and tolerances for these requirements.

2.2 The frames covered by this standard include designs in which the jamb width may be readily adjusted by means of appropriate jamb liners; and they conform to the requirements of modular coordination.

2.3 Standard stock layouts and designs are given herein for the frames listed below; however, minor variations which do

Exterior frames	Grade	Sizes and details[1]
Window.....	A	See figs. N.W. 1 to N.W. 9.
Casement.....	A	See fig. N.W. 10.
Cellar.....	A	See figs. N.W. 11 to N.W. 13.
Door.....	A	See figs. N.W. 14 to N.W. 17.

[1]Figures N.W. 1 to 17 (pages 8 to 23) are not drawn to scale.

not affect the quality or proper functioning of the frame may occur in accordance with the standard practice of the individual manufacturer.

3. GENERAL REQUIREMENTS

3.1 All standard stock wood frames shall meet the following quality requirements:

3.2 *Moisture content.*--All frames shall be made from lumber of approved species (see par. 3.3) that has been dried to a moisture content of 6 to 12 percent before fabrication.

3.3 *Species of lumber.*--Lumber used for window and door frames shall be of the species listed below. Not more than two species may be used in any one frame.

Incense cedar	Western larch	Southern yellow pine
Western red cedar	Idaho white pine	Sugar pine
Cypress	Lodgepole pine	Redwood[1]
Douglas fir	Northern white pine	Engelmann spruce
White fir	Parana pine	Sitka spruce
West coast hemlock	Ponderosa pine	

[1]Where redwood is used, nails shall be either galvanized or nonferrous.

3.4 *Workmanship.*--Frames shall be consistently well manufactured at all times.

3.5 *Construction.*--At the option of the manufacturer, frames may be manufactured with the side jambs dadoed to receive the head jambs and sills, or the cross-members dadoed to receive the side jambs. Frames may be machined for mechanical balances or for pulleys, at the option of the purchaser. When machined for pulleys they shall also have weight access pockets cut, broken, and screwed into place according to accepted practice.

3.6 *Thickness and width.*--The minimum thicknesses and widths of frame parts shall be as shown in the details in figures N.W. 1 through 17, with no minus tolerance.

3.7 *Size of nominal opening.*--The width and height of the nominal opening formed by the frame to receive the door or sash shall be as shown in the details in figures N.W. 1 through 17, with a tolerance of 1/32 inch, plus or minus.

3.8 *Preservative treatment.*--All frames shall be treated with a water-repellent preservative at the factory in accordance with the minimum standards of the National Woodwork Manufacturers Association.[1]

[1]Copies of the standards may be secured from the National Woodwork Manufacturers Association, 332 South Michigan Ave., Chicago 4, Ill.

3.9 *Finger-joints.*--A quality finger-joint is defined as a series of fingers machined on the ends of two pieces to be joined, which mesh together and are held firmly in position by a water-resistant adhesive applied in accordance with the adhesive manufacturer's specifications. The water-resistant adhesive shall conform to Federal Specification MMM-A-125, or be such as may be used for type II plywood (water-resistant bond) as defined in Commercial Standard CS35-56 (or later revision), or equal. The parts joined by the finger-joint must be precision machined. Finger-joints as defined herein shall be allowed in all parts except the sill.

3.10 *Interior door jambs.*--The minimum thickness of interior door jambs shall be 3/4 inch.

3.11 *Pitch.*--The minimum pitch of the sills shall be:

For window frames..... 2-1/2 in. to 12 in.
For door frames..... 1 in. to 12 in.

NOTE.--The bottom rails of standard stock windows are beveled to a pitch of 14° (approximately 3 to 12 in.).

3.12 *Plugs.*--Parts wider than 2-1/2 inches, and not exposed when the frame is in place and trimmed, may contain plugs. Each plug shall be of the same species as the frame part, shall be sized for a tight fit, shall completely fill the recess cut for the plug, with the grain of the plug parallel to the grain of the frame part, and shall be held firmly in position by a water-resistant adhesive applied in accordance with the adhesive manufacturer's specifications. The water-resistant adhesive shall conform to Federal Specification MMM-A-125, or be such as may be used for type II plywood (water-resistant bond) as defined in Commercial Standard CS35-56 (or later revision), or equal.

4. GRADING

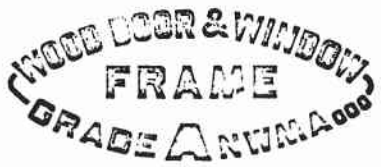
4.1 *Grade A* standard stock wood frames shall be practically free from defects in all exposed parts. Light-brown water stain and light-red kilnburn are not considered defects. Parts that are not exposed when the frame is in place and trimmed may contain stain, pitch streaks, knots, or any other defect that will not affect the strength of the frame.

4.1.1 In defining defects, grading rules of the Southern Pine Association, West Coast Lumber Association, Western Pine Association, National Hardwood Lumber Association, California Redwood Association, and of other associations not mentioned herein that are applicable to species not covered by the above-named associations, shall govern on the species covered by the respective association's grading rules.

4.2 In order to assure the purchaser that he is getting wood frames of the quality specified, producers may individually or in concert with their trade associations, issue guaranties, or grade-mark each frame by stamp, brand, or label as conforming to this standard. The following wording is recommended for the label:

> This *Grade A* wood frame is guaranteed by the manufacturer to conform to Commercial Standard CS208-57, as developed by the trade under the procedure of the Commodity Standards Division, and issued by the U. S. Department of Commerce.
>
> _____
> (Name of manufacturer)

4.3 *Grade marking.*--The following grade-mark has been adopted by the National Woodwork Manufacturers Association, Inc., as a means of assuring consumers and distributors that wood frames conform to the high standards of quality defined herein.



5. NOMENCLATURE AND DEFINITIONS

Blind stop.--A strip of wood machined so as to fit the exterior edges of the pulley stile or jamb and keep the sash in place.

Extension blind stop.--A molded piece, usually of the same thickness as the blind stop, and tongued on one edge to engage a plow in the back edge of the blind stop, thus increasing its width and improving the weathertightness of the frame.

Head stop.--A thin strip of wood placed on the bottom side of the head jamb so as to keep the top sash of a plain rail window in place.

Inside stop.--A thin strip of wood placed on the inside of the side jambs so as to hold the lower sash in place, and also serve as one side of the sash run for a double-hung window.

Outside stop.--A thin strip of wood placed on the inside of the side jambs so as to hold the lower sash in place, and also serve as one side of the sash run for a plain rail window.

Parting stop.--A thin strip of wood let into the jamb of a window frame to separate the sash.

Casing.--Molding of various widths and thicknesses used to trim door and window openings.

Dado.--A rectangular groove cut across the grain of a frame member.

Drip cap.--A molding placed on the top of the head casing of a door or window frame.

Frame (wood).--A frame is a group of wood parts so machined and assembled as to form an enclosure and support for a window, sash, or door.

Jamb.--The parts of a frame which surround and contact the vertical and top horizontal edges of a door, window, or sash.

Head jamb.--The horizontal member forming the top of the opening.

Side jamb.--The upright member forming the side of the opening.

Rabbeted jamb.--A jamb with a rabbet run on one or both edges to receive a door or sash.

Jamb liner.--A small strip of wood, either surfaced on four sides or tongued on one edge, which, when applied to the inside edge of a jamb, increases its width for use in thicker walls.

Sill.--The horizontal member forming the bottom of a frame.

Main sill.--The lower and thicker member of a two-piece sill.

Subsill.--The upper and thinner member of a two-piece sill.

Pulley stile.--A side jamb into which a pulley is fixed and along which the sash slides.

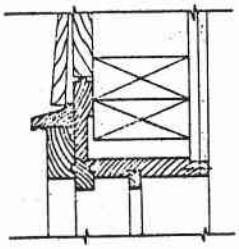
6. EFFECTIVE DATE

6.1 Having been passed through the regular procedure of the Commodity Standards Division, and approved by the acceptors hereinafter listed, this Commercial Standard was issued by the United States Department of Commerce, effective from February 1, 1957.

EDWIN W. ELY,
Chief, Commodity Standards Division.

NOTE.--All dimensions of basic frame parts in figures N.W. 1 to N.W. 17 are in inches.

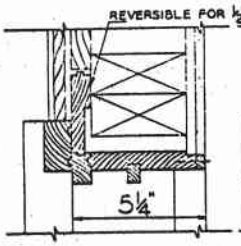
N.W. 1
WINDOW FRAME



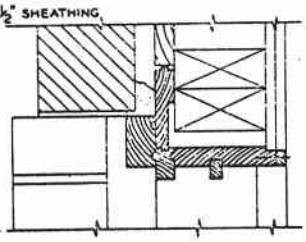
HEAD

BASIC FRAME PARTS

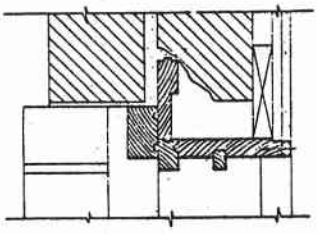
JAMBS	$\frac{3}{4} \times 4\frac{1}{2}$	FACE INC. LINER
HEAD CASING	$1\frac{3}{32} \times 2$	
SIDE CASINGS	$1\frac{3}{32} \times 2$	
SILL	$1\frac{5}{16} \times 7\frac{1}{8}$	
DRIP CAP	$1\frac{1}{16} \times 1\frac{5}{8}$	
BLIND STOPS	$\frac{3}{4} \times 1\frac{1}{4}$	FACE
PARTING STOPS	$\frac{1}{2} \times \frac{3}{4}$	
EXTENSION BLIND STOPS	$\frac{3}{4} \times 3\frac{1}{8}$	O.A.



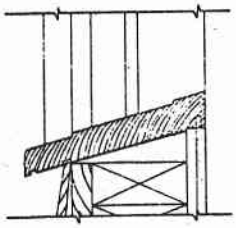
JAMB
FRAME



JAMB
BRICK VENEER



JAMB
SOLID MASONRY



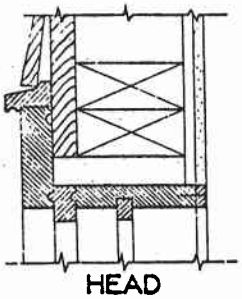
SILL

ALTERNATE CASING

WINDOW OPENING

WIDTHS		HEIGHTS	
GL. SIZE 2 LIGHT	OPNG. SIZE	GL. SIZE 2 LIGHT	OPNG. SIZE
12"	1' 4"	12"	2' 6"
16"	1' 8"	14"	2' 10"
20"	2' 0"	16"	3' 2"
24"	2' 4"	18"	3' 6"
28"	2' 8"	20"	3' 10"
32"	3' 0"	22"	4' 2"
36"	3' 4"	24"	4' 6"
40"	3' 8"	26"	4' 10"
44"	4' 0"	28"	5' 2"
48"	4' 4"	30"	5' 6"
		32"	5' 10"
		34"	6' 2"
		36"	6' 6"

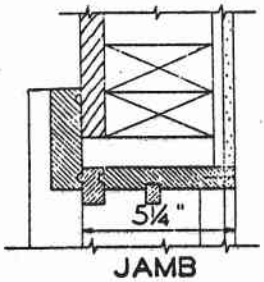
N.W. 2
WINDOW FRAME



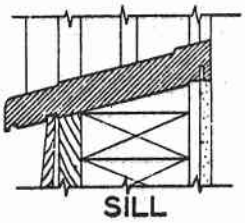
HEAD

BASIC FRAME PARTS

JAMBS	3/4 x 4 1/2	FACE INC. LINER
HEAD CASING	13/32 x 3 1/2	
SIDE CASINGS	13/32 x 3 1/2	
SILL	15/16 x 7 1/8	
DRIP CAP	1 1/16 x 1 5/8	
BLIND STOPS	3/4 x 1 1/4	FACE
PARTING STOPS	1/2 x 3/4	



JAMB

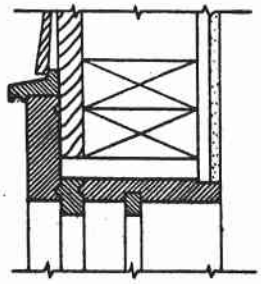


SILL

WINDOW OPENING

WIDTHS		HEIGHTS	
GL. SIZE 2 LIGHT	OP'NG SIZE	GL. SIZE 2 LIGHT	OP'NG SIZE
12"	1'4"	12"	2' 6"
16"	1'8"	14"	2' 10"
20"	2'0"	16"	3' 2"
24"	2'4"	18"	3' 6"
28"	2'8"	20"	3' 10"
32"	3'0"	22"	4' 2"
36"	3'4"	24"	4' 6"
40"	3'8"	26"	4' 10"
44"	4'0"	28"	5' 2"
48"	4'4"	30"	5' 6"
		32"	5' 10"
		34"	6' 2"
		36"	6' 6"

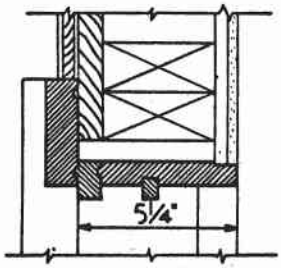
N.W.3
WINDOW FRAME



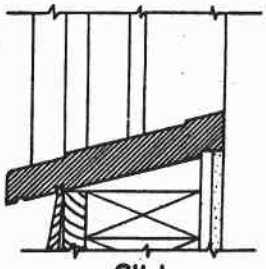
HEAD

BASIC FRAME PARTS

JAMBS	3/4 X 4 1/2 FACE
HEAD CASING	1 3/32 X 3 1/2
SIDE CASINGS	1 3/32 X 3 1/2
SILL	1 5/16 X 7 1/8
DRIP CAP	1 1/16 X 1 5/8
BLIND STOPS	3/4 X 1 1/4 FACE
PARTING STOPS	1/2 X 3/4



JAMB

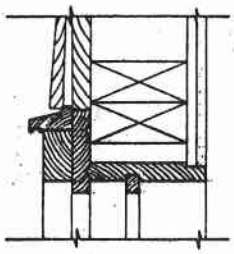


SILL

WINDOW OPENING

WIDTHS		HEIGHTS	
GL. SIZE 2 LIGHT	OP'NG SIZE	GL. SIZE 2 LIGHT	OP'NG SIZE
12"	1'4"	12"	2'6"
16"	1'8"	14"	2'10"
20"	2'0"	16"	3'2"
24"	2'4"	18"	3'6"
28"	2'8"	20"	3'10"
32"	3'0"	22"	4'2"
36"	3'4"	24"	4'6"
40"	3'8"	26"	4'10"
44"	4'0"	28"	5'2"
48"	4'4"	30"	5'6"
		32"	5'10"
		34"	6'2"
		36"	6'6"

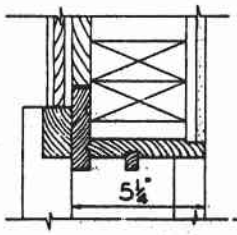
N.W. 4
WINDOW FRAME



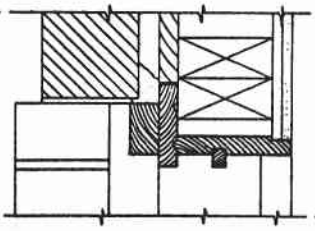
HEAD

BASIC FRAME PARTS

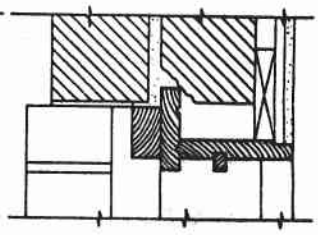
JAMBS	3/4 x 4 1/2 FACE
HEAD CASING	13/32 x 2
SIDE CASINGS	13/32 x 2
SILL	1 5/16 x 7 1/8
DRIP CAP	1 1/16 x 1 5/8
BLIND STOPS	3/4 x 3 1/4
PARTING STOPS	1/2 x 3/4



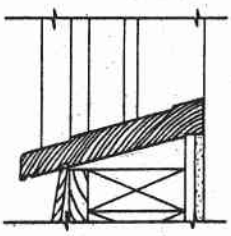
JAMB
FRAME



JAMB
BRICK VENEER



JAMB
SOLID MASONRY



SILL

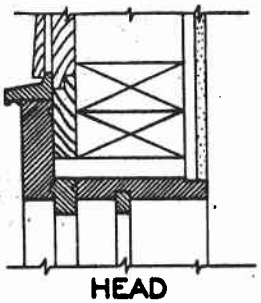
NOTE: PROFILE IS OPTIONAL WITH MANUFACTURER

ALTERNATE CASING

WINDOW OPENING

WIDTHS		HEIGHTS	
GL. SIZE 2 LIGHT	OP'NG SIZE	GL. SIZE 2 LIGHT	OP'NG SIZE
12"	1'4"	12"	2' 6"
16"	1'8"	14"	2' 10"
20"	2' 0"	16"	3' 2"
24"	2' 4"	18"	3' 6"
28"	2' 8"	20"	3' 10"
32"	3' 0"	22"	4' 2"
36"	3' 4"	24"	4' 6"
40"	3' 8"	26"	4' 10"
44"	4' 0"	28"	5' 2"
48"	4' 4"	30"	5' 6"
		32"	5' 10"
		34"	6' 2"
		36"	6' 6"

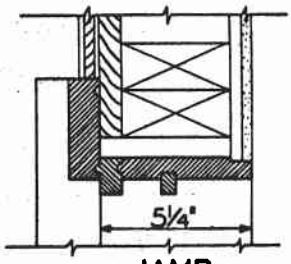
N.W. 5
WINDOW FRAME



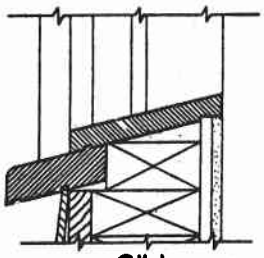
HEAD

BASIC FRAME PARTS

JAMBS	3/4 x 4 1/2 FACE
HEAD CASING	13/32 x 3 1/2
SIDE CASINGS	13/32 x 3 1/2
DRIP CAP	1 1/16 x 1 5/8
BLIND STOPS	3/4 x 1 1/4 FACE
PARTING STOPS	1/2 x 3/4
MAIN SILL	1 5/16 O.A. x 3 1/2
SUB SILL	3/4 x 5 5/16



JAMB

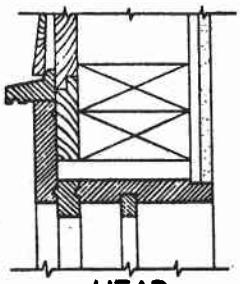


SILL

WINDOW OPENING

WIDTHS		HEIGHTS	
GL. SIZE 2 LIGHT	OP'NG SIZE	GL. SIZE 2 LIGHT	OP'NG SIZE
12"	1'4"	12"	2' 6"
16"	1'8"	14"	2' 10"
20"	2'0"	16"	3' 2"
24"	2'4"	18"	3' 6"
28"	2'8"	20"	3' 10"
32"	3'0"	22"	4' 2"
36"	3'4"	24"	4' 6"
40"	3'8"	26"	4' 10"
44"	4'0"	28"	5' 2"
48"	4'4"	30"	5' 6"
		32"	5' 10"
		34"	6' 2"
		36"	6' 6"

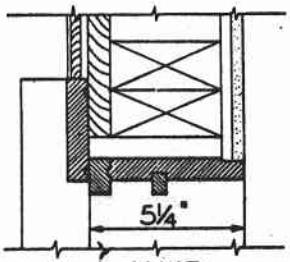
N.W. 6
WINDOW FRAME



HEAD

BASIC FRAME PARTS

JAMBS	3/4 x 4 1/2 FACE
HEAD CASING	3/4 x 3 1/2
SIDE CASINGS	3/4 x 3 1/2
DRIP CAP	1 1/16 x 1 5/8
BLIND STOPS	3/4 x 1 1/4 FACE
PARTING STOPS	1/2 x 3/4
MAIN SILL	1 5/16 O.A. x 3 1/2
SUB SILL	3/4 x 5 5/16



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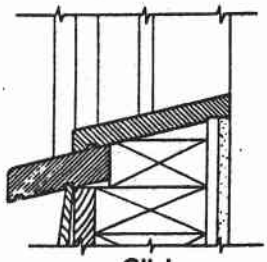
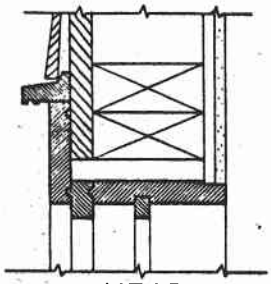


SILL

WINDOW OPENING

WIDTHS		HEIGHTS	
GL. SIZE 2 LIGHT	OP'NG SIZE	GL. SIZE 2 LIGHT	OP'NG SIZE
12"	1' 4"	12"	2' 6"
16"	1' 8"	14"	2' 10"
20"	2' 0"	16"	3' 2"
24"	2' 4"	18"	3' 6"
28"	2' 8"	20"	3' 10"
32"	3' 0"	22"	4' 2"
36"	3' 4"	24"	4' 6"
40"	3' 8"	26"	4' 10"
44"	4' 0"	28"	5' 2"
48"	4' 4"	30"	5' 6"
		32"	5' 10"
		34"	6' 2"
		36"	6' 6"

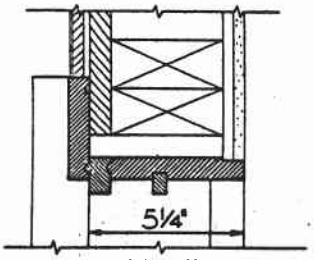
N.W. 7
WINDOW FRAME



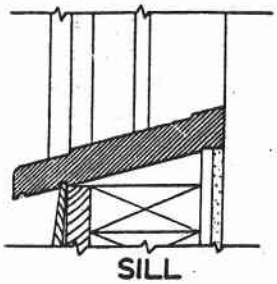
HEAD

BASIC FRAME PARTS

JAMBS	3/4 x 4 1/2 FACE
HEAD CASING	3/4 x 3 1/2
SIDE CASINGS	3/4 x 3 1/2
SILL	1 5/16 x 7 1/8
DRIP CAP	1 1/16 x 1 5/8
BLIND STOPS	3/4 x 1 1/4 FACE
PARTING STOPS	1/2 x 3/4



JAMB

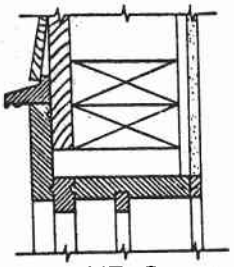


SILL

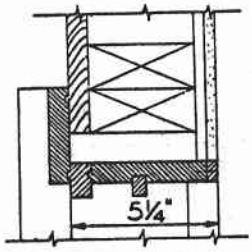
WINDOW OPENING

WIDTHS		HEIGHTS	
GL. SIZE 2 LIGHT	OP'NG. SIZE	GL. SIZE 2 LIGHT	OP'NG SIZE
12"	1'4"	12"	2' 6"
16"	1'8"	14"	2' 10"
20"	2'0"	16"	3' 2"
24"	2'4"	18"	3' 6"
28"	2'8"	20"	3' 10"
32"	3'0"	22"	4' 2"
36"	3'4"	24"	4' 6"
40"	3'8"	26"	4' 10"
44"	4'0"	28"	5' 2"
48"	4'4"	30"	5' 6"
		32"	5' 10"
		34"	6' 2"
		36"	6' 6"

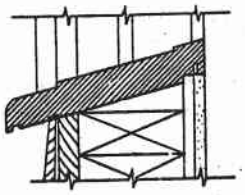
N.W. 8
WINDOW FRAME



HEAD



JAMB



SILL

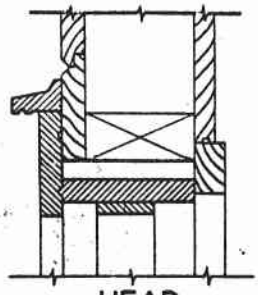
BASIC FRAME PARTS

JAMBS	¾ x 4½	FACE INC. LINER
HEAD CASING	¾ x 3½	
SIDE CASINGS	¾ x 3½	
SILL	15/16 x 7⅛	
DRIP CAP	1 1/16 x 1⅝	
BLIND STOPS	¾ x 1¼	FACE
PARTING STOPS	½ x ¾	

WINDOW OPENING

WIDTHS		HEIGHTS	
GL. SIZE 2 LIGHT	OP'NG SIZE	GL. SIZE 2 LIGHT	OP'NG SIZE
12"	1' 4"	12"	2' 6"
16"	1' 8"	14"	2' 10"
20"	2' 0"	16"	3' 2"
24"	2' 4"	18"	3' 6"
28"	2' 8"	20"	3' 10"
32"	3' 0"	22"	4' 2"
36"	3' 4"	24"	4' 6"
40"	3' 8"	26"	4' 10"
44"	4' 0"	28"	5' 2"
48"	4' 4"	30"	5' 6"
		32"	5' 10"
		34"	6' 2"
		36"	6' 6"

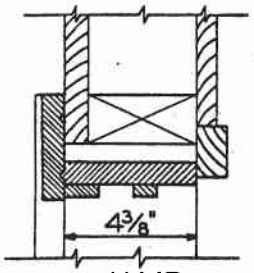
N.W. 9
WINDOW FRAME
(PLAIN RAIL)



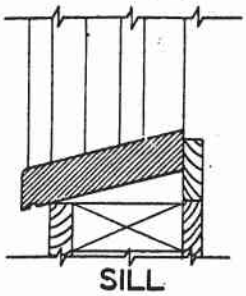
HEAD

BASIC FRAME PARTS

JAMBS	3/4 x 4 3/8 FACE
HEAD CASING	3/4 x 3 1/2
SIDE CASINGS	3/4 x 3 1/2
SILL	1 5/16 x 5 3/8
DRIP CAP	1 1/16 x 1 5/8
HEAD STOP	3/8 x 1 7/8
INSIDE STOPS	3/8 x 3/4
OUTSIDE STOPS	3/8 x 1 1/8



JAMB

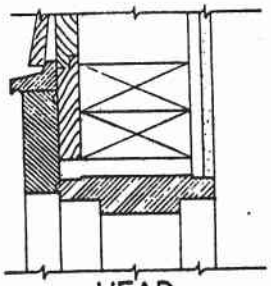


SILL

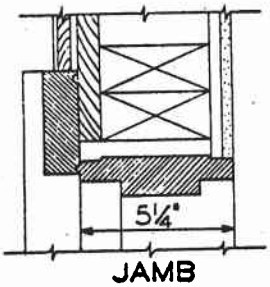
WINDOW OPENING

WIDTHS		HEIGHTS	
GL. SIZE 2 LIGHT	OP'NG SIZE	GL. SIZE 2 LIGHT	OP'NG SIZE
12"	1'4"	12"	2'6"
16"	1'8"	14"	2'10"
20"	2'0"	16"	3'2"
24"	2'4"	18"	3'6"
28"	2'8"	20"	3'10"
32"	3'0"	22"	4'2"
36"	3'4"	24"	4'6"
40"	3'8"	26"	4'10"
44"	4'0"	28"	5'2"
48"	4'4"	30"	5'6"
		32"	5'10"
		34"	6'2"
		36"	6'6"

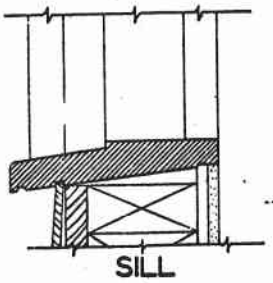
N.W. 10
CASEMENT FRAME



HEAD



JAMB



SILL

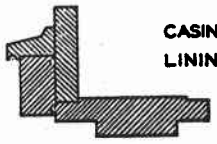
BASIC FRAME PARTS

JAMBS	$1\frac{5}{16} \times 5\frac{1}{4}$ FACE
HEAD CASING	$1\frac{3}{32} \times 3\frac{1}{2}$
SIDE CASINGS	$1\frac{3}{32} \times 3\frac{1}{2}$
SILL	$1\frac{5}{16} \times 7\frac{1}{8}$
DRIP CAP	$1\frac{1}{16} \times 1\frac{5}{8}$

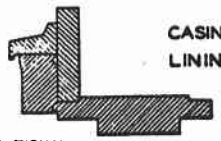
SASH SIZES

WIDTHS		HEIGHTS
SINGLE SASH	PAIRS	
1' 4"	2' 8"	2' 6"
1' 8"	3' 4"	2' 10"
2' 0"	4' 0"	3' 2"
2' 4"		3' 6"
		3' 10"
		4' 2"
		4' 6"
		4' 10"
		5' 2"

ALTERNATE CASINGS WITH LINING



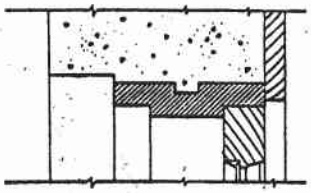
CASING-$1\frac{3}{32} \times 2$
LINING-$\frac{3}{4} \times 3\frac{1}{4}$



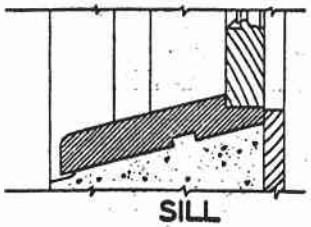
CASING-$1\frac{5}{16} \times 2$
LINING-$\frac{3}{4} \times 3\frac{1}{4}$

NOTE:
PROFILE IS OPTIONAL
WITH MANUFACTURER

N.W. 11
CELLAR FRAME



HEAD



SILL

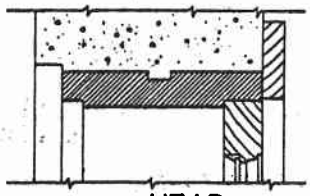
BASIC FRAME PARTS

HEAD JAMB & SIDE JAMBS ..... 15/16 x 5 1/4
SILL ..... 15/16 x 7 1/16

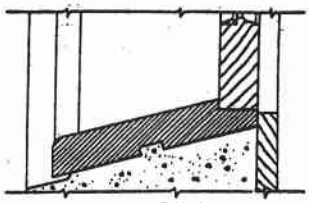
SASH SIZES

WIDTHS	HEIGHTS
1'8"	1'3"
2'0"	1'5"
2'4"	1'7"
2'8"	1'9"
3'0"	1'11"
3'4"	2'1"

N.W. 12
CELLAR FRAME



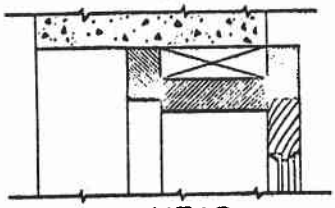
HEAD



SILL

HEAD JAMB & SIDE JAMBS ..... 15/16 x 7
SILL ..... 15/16 x 7 1/16

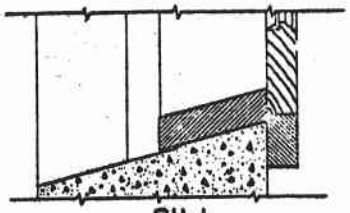
N.W. 13
CELLAR FRAME



HEAD

BASIC FRAME PARTS

HEAD JAMB & SIDE JAMBS.....$1\frac{1}{16} \times 3\frac{1}{2}$
SILL .....$1\frac{1}{16} \times 3\frac{9}{16}$
BRICK MOULD.....$1\frac{1}{16} \times 1\frac{3}{4}$
SASH FRAME.....$1\frac{1}{16} \times 1\frac{3}{4}$

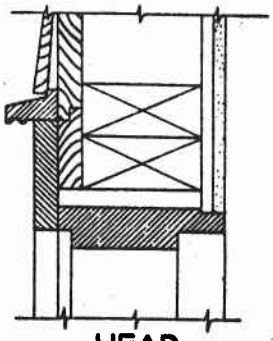


SILL

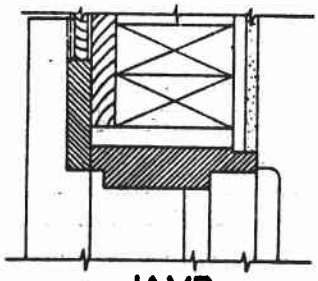
SASH SIZES

WIDTHS	HEIGHTS
1'8"	1'3"
2'0"	1'5"
2'4"	1'7"
2'8"	1'9"
3'0"	1'11"
3'4"	2'1"

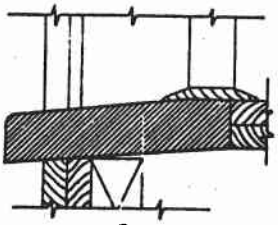
N.W. 14
DOOR FRAME



HEAD



JAMB



SILL

BASIC FRAME PARTS

JAMBS	$1\frac{5}{16} \times 5\frac{1}{4}$
HEAD CASING	$\frac{3}{4} \times 3\frac{1}{2}$
SIDE CASINGS	$\frac{3}{4} \times 3\frac{1}{2}$
SILL	$1\frac{5}{8} \times 7\frac{1}{8}$
DRIP CAP	$1\frac{1}{16} \times 1\frac{5}{8}$

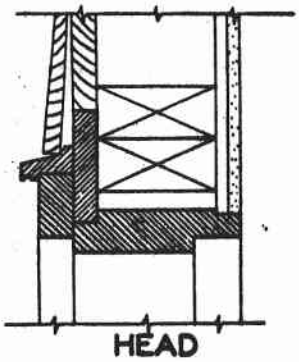
DOOR SIZES*

WIDTHS	HEIGHTS
2'6"	6'6"
2'8"	6'8"
3'0"	7'0"
3'6"	7'6"
4'0"	8'0"
5'0"	
6'0"	
8'0"	

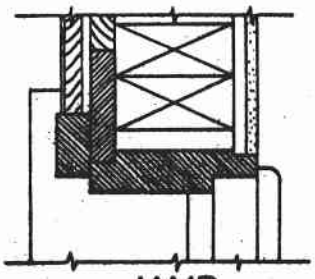
* HEIGHTS SHOWN DO NOT INCLUDE ALLOWANCES FOR THRESHOLDS

OPTIONAL SILL $1\frac{5}{16} \times 7\frac{1}{8}$

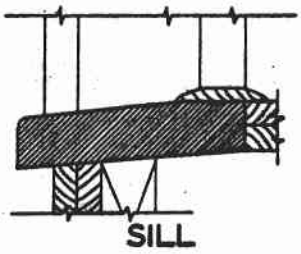
N.W. 15
DOOR FRAME



HEAD



JAMB



SILL

BASIC FRAME PARTS

JAMBS	$1\frac{5}{16} \times 5\frac{1}{4}$
HEAD CASING	$1\frac{3}{32} \times 2$
SIDE CASINGS	$1\frac{3}{32} \times 2$
SILL	$1\frac{5}{8} \times 7\frac{1}{8}$
DRIP CAP	$1\frac{1}{16} \times 1\frac{5}{8}$
OUTSIDE LININGS	$\frac{3}{4} \times 3\frac{1}{2}$

DOOR SIZES*

WIDTHS	HEIGHTS
2'6"	6'6"
2'8"	6'8"
3'0"	7'0"
3'6"	7'6"
4'0"	8'0"
5'0"	
6'0"	
8'0"	

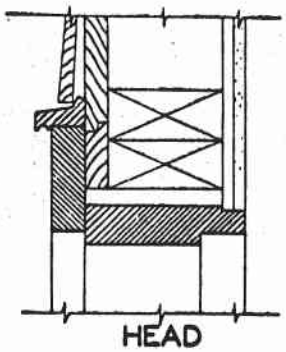
* HEIGHTS SHOWN DO NOT INCLUDE ALLOWANCES FOR THRESHOLDS.

NOTE: PROFILE IS OPTIONAL WITH MANUFACTURER

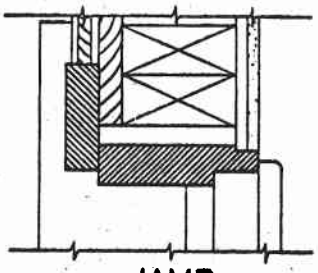
ALTERNATE CASING

OPTIONAL SILL $1\frac{5}{16} \times 7\frac{1}{8}$

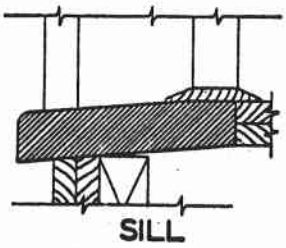
N.W. 16
DOOR FRAME



HEAD



JAMB



SILL

BASIC FRAME PARTS

JAMBS	$1\frac{5}{16} \times 5\frac{1}{4}$
HEAD CASING	$1\frac{3}{32} \times 3\frac{1}{2}$
SIDE CASINGS	$1\frac{3}{32} \times 3\frac{1}{2}$
SILL	$1\frac{5}{8} \times 7\frac{1}{8}$
DRIP CAP	$1\frac{1}{16} \times 1\frac{5}{8}$

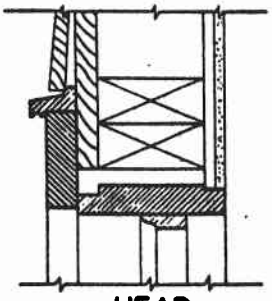
DOOR SIZES*

WIDTHS	HEIGHTS
2'6"	6'6"
2'8"	6'8"
3'0"	7'0"
3'6"	7'8"
4'0"	8'0"
5'0"	
6'0"	
8'0"	

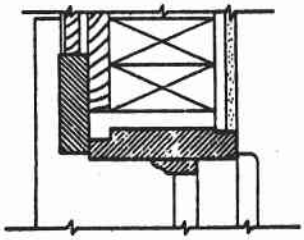
* HEIGHTS SHOWN DO NOT INCLUDE ALLOWANCES FOR THRESHOLDS

OPTIONAL SILL $1\frac{5}{16} \times 7\frac{1}{8}$

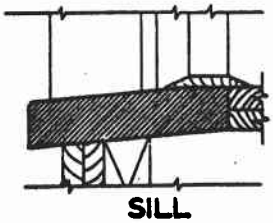
N.W. 17
DOOR FRAME



HEAD



JAMB



SILL

BASIC FRAME PARTS

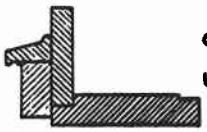
JAMBS	$1\frac{3}{32} \times 5\frac{1}{4}$
HEAD CASING	$1\frac{3}{32} \times 3\frac{1}{2}$
SIDE CASINGS	$1\frac{3}{32} \times 3\frac{1}{2}$
SILL	$1\frac{5}{8} \times 7\frac{1}{8}$
DRIP CAP	$1\frac{1}{16} \times 1\frac{5}{8}$
STOPS	$\frac{1}{2} \times 1\frac{5}{8}$

DOOR SIZES*

WIDTHS	HEIGHTS
2'6"	6'6"
2'8"	6'8"
3'0"	7'0"
3'6"	7'6"
4'0"	8'0"
5'0"	
6'0"	
8'0"	

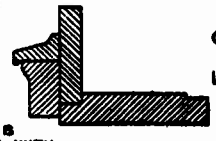
*HEIGHTS SHOWN DO NOT INCLUDE ALLOWANCES FOR THRESHOLDS

ALTERNATE CASING WITH LINING



CASING- $1\frac{3}{32} \times 2$

LINING- $\frac{3}{4} \times 3\frac{1}{2}$



CASING- $1\frac{5}{16} \times 2$

LINING - $\frac{3}{4} \times 3\frac{1}{2}$

NOTE:
PROFILE B
OPTIONAL WITH
MANUFACTURER

OPTIONAL SILL $1\frac{5}{16} \times 7\frac{1}{8}$

USCOMM-NBS-DC

HISTORY OF PROJECT

On November 5, 1953, the National Woodwork Manufacturers Association requested the cooperation of the Commodity Standards Division in the establishment of a Commercial Standard for standard stock wood window and door frames.

The proposed standard was first submitted to interested industry and governmental organizations for advance review, and then adjusted in accordance with the comments received. On April 13, 1956, the recommended standard was circulated to the industry for further consideration and acceptance. Comments received from a number of organizations indicated that some additional adjustments were necessary, and a listing of the suggested modifications was referred on October 1, 1956, to all acceptors of record.

Firms and others interested submitted official acceptances estimated to represent a satisfactory majority of the production volume, and a sufficient cross section of the industry to insure successful application of the standard. On January 2, 1957, the promulgation of this standard as CS208-57 was announced, effective for new production from February 1, 1957.

Project Manager: H. A. Bonnet, Commodity Standards Division, Office of Technical Services.

Technical Advisers: George W. Shaw, R. L. Lloyd, and James P. Thompson, Building Technology Division, National Bureau of Standards.

STANDING COMMITTEE

The following individuals comprise the membership of the standing committee organized by the industry, which is to review, prior to circulation for acceptance, revisions proposed to keep the standard abreast of progress. Comments concerning the standard and suggestions for revision may be addressed to any member of the committee or to the Commodity Standards Division, Office of Technical Services, U.S. Department of Commerce, which acts as secretary for the committee.

J. H. SAMPSON, White Pine Sash Co., E. 4005 Broadway, Spokane 10, Wash. (Chairman).

F. F. BEIL, Curtis Cos., Inc., Clinton, Iowa.

O. C. SCHIELD, Hurd Millwork Corp., Medford, Wis.

O. B. SMITH, Wm. Cameron & Co., P. O. Box 1069, Waco, Tex. (representing Southern Sash & Door Jobbers Association).

CRAY J. COPPINS, Whitmer-Jackson Co., Inc., P. O. Box 556, Massillon, Ohio (representing Northern Sash & Door Jobbers Association).

R. GOMMEL ROESSNER, Associate Professor, School of Architecture, University of Texas, Austin 12, Tex. (representing American Institute of Architects).

Prefabricated Home Manufacturers' Institute--invited to name a representative.

CS208-57

ACCEPTANCE OF COMMERCIAL STANDARD

If an acceptance has not previously been filed, this sheet properly filled in, signed, and returned will provide for the recording of your organization as an acceptor of this Commercial Standard.

Date _____

Commodity Standards Division,
Office of Technical Services,
U. S. Department of Commerce,
Washington 25, D. C.

Gentlemen:

We believe that this Commercial Standard constitutes a useful standard of practice, and we individually plan to utilize it as far as practicable in the

production[1] distribution[1] purchase[1] testing[1]

of standard stock wood window and door frames. We reserve the right to depart from it as we deem advisable.

We understand, of course, that only those products which actually comply with the standard in all respects can be identified or labeled as conforming thereto.

Signature of authorized officer _____
(In ink)

(Kindly typewrite or print the following lines)

Name and title of above officer _____

Organization _____
(Fill in exactly as it should be listed)

Street address _____

City, zone, and State _____

(Cut on this line)

[1]Underscore the one that applies. Please see that separate acceptances are filed for all subsidiary companies and affiliates which should be listed separately as acceptors. In the case of related interests, trade associations, trade papers, etc., desiring to record their general support, the words "General support" should be added after the signature.

TO THE ACCEPTOR

The following statements answer the usual questions arising in connection with the acceptance and its significance:

1. *Enforcement.*—Commercial Standards are commodity specifications voluntarily established by mutual consent of those concerned. They present a common basis of understanding between the producer, distributor, and consumer and should not be confused with any plan of governmental regulation or control. The United States Department of Commerce has no regulatory power in the enforcement of their provisions, but since they represent the will of the interested groups as a whole, their provisions through usage soon become established as trade customs, and are made effective through incorporation into sales contracts by means of labels, invoices, and the like.

2. *The acceptor's responsibility.*—The purpose of Commercial Standards is to establish, for specific commodities, nationally recognized grades or consumer criteria, and the benefits therefrom will be measurable in direct proportion to their general recognition and actual use. Instances will occur when it may be necessary to deviate from the standard, and the signing of an acceptance does not preclude such departures; however, such signature indicates an intention to follow the standard, where practicable, in the production, distribution, or consumption of the article in question.

3. *The Department's responsibility.*—The major function performed by the Department of Commerce in the voluntary establishment of Commercial Standards on a nationwide basis is fourfold: first, to act as an unbiased coordinator to bring all interested parties together for the mutually satisfactory adjustment of trade standards; second, to supply such assistance and advice as past experience with similar programs may suggest; third, to canvass and record the extent of acceptance and adherence to the standard on the part of producers, distributors, and users; and fourth, after acceptance, to publish and promulgate the standard for the information and guidance of buyers and sellers of the commodity.

4. *Announcement and promulgation.*—When the standard has been endorsed by a satisfactory majority of production or consumption in the absence of active, valid opposition, the success of the project is announced. If, however, in the opinion of the standing committee or of the Department of Commerce the support of any standard is inadequate, the right is reserved to withhold promulgation and publication.

ACCEPTORS

The individual organizations listed below have accepted this standard for use as far as practicable in the production, distribution, purchase, or testing of standard stock wood window and door frames. In accepting the standard they reserved the right to depart from it as they individually deem advisable. It is expected that products which actually comply with the requirements of this standard in all respects will be regularly identified or labeled as conforming thereto, and that purchasers will require such specific evidence of conformity.

ASSOCIATIONS

(General Support)

American Specification Institute, Chicago, Ill.
Associated General Contractors of America, Inc., Washington, D. C.
Carolina Lumber & Building Supply Association, Charlotte, N. C.
Douglas Fir Plywood Association, Tacoma, Wash.
Michigan Association of Traveling Lumber, Sash & Door Salesmen, Detroit, Mich.
Michigan Retail Lumber Dealers Association, Lansing, Mich.
Mississippi Retail Lumber Dealers Association, Inc., Jackson, Miss.
National Woodwork Manufacturers Association, Chicago, Ill.
Ponderosa Pine Woodwork, Chicago, Ill.
Prefabricated Home Manufacturers' Institute, Washington, D. C.
Southern Pine Association, New Orleans, La.
Southern Pine Inspection Bureau, New Orleans, La.

FIRMS AND OTHER INTERESTS

Addison-Rudesal, Inc., Atlanta, Ga.
Allied Millwork & Manufacturing Co., Center Line, Mich.
American Sash & Door Co., Kansas City, Mo.
Andrews, C. E., Lumber Co., New Bethlehem, Pa.
Associated Door & Plywood Co., Chicago, Ill.
Bardwell-Robinson Co., Fargo, N. Dak.
Baxter, C. B., & Co., Kansas City, Mo.
Beasley & Sons Co., Nashville, Tenn.
Beuttler, William, Sioux City, Iowa
Biles-Coleman Lumber Co., Inc., Omak, Wash.
Binswanger & Co., Inc., Richmond, Va.; Roanoke, Va.; Greensboro, N. C.; Fayetteville, N. C.; Columbia, S. C.; Greenville, S.C.; Macon, Ga.; Florence, S. C.
Birmingham Sash & Door Co., Birmingham, Ala.
Blount Lumber Co., Lacona, N. Y.
Bosman & Casson, Inc., Union, N. J.
Bridal Veil Lumber & Box Co., Bridal Veil, Oreg.
Brockway-Smith-Haigh-Lovell Co., Boston, Mass.
Brust & Brust, Milwaukee, Wis.
Buffalo, City of, Division of Buildings, Department of Public Works, Buffalo, N. Y.

Buffelen Sales Co. (of Tacoma, Wash.), Fort Worth, Tex.
Cameron, Wm., & Co., Waco, Tex.
Carnahan Manufacturing Co., Inc., Loogootee, Ind.
Carr, Adams & Collier Co., Dubuque, Iowa
Cascade Wood Products, Inc., Medford, Oreg.
Cellarius, Charles F., Cincinnati, Ohio
Central of Georgia Railway Co., Savannah, Ga.
Central Woodwork, Inc., Memphis, Tenn.
Cincinnati Sash & Door Co., Cincinnati, Ohio
City Lumber Yard, Iron Mountain, Mich.
Combs Lumber Co., Inc., Lexington, Ky.
Conrad & Cummings, Binghamton, N. Y.
Curtis Cos., Inc., Clinton, Iowa; Chicago, Ill.; Lincoln, Nebr.; Minneapolis, Minn.; New London, Wis.; Scranton, Pa.; Sioux City, Iowa; Wausau, Wis.
Curtis, Ros, Co., Inc., Milford, Mich.
Darby, Bogner & Associates, Milwaukee, Wis.
Davidson Sash & Door Co., Inc., Lake Charles, La.
Dayton Sash & Door Co., Dayton, Ohio
Deer Park Pine Industry, Inc., Deer Park, Wash.
DeJarnette, Charles Wagner, Des Moines, Iowa
Detroit Department of Public Works, Detroit, Mich.
Diamond Match Co., Chico, Calif.
Donlin Co., St. Cloud, Minn.
Edwards Sash, Door & Lumber Co., Tampa, Fla.
Farley-Loetscher Co., Sioux Falls, S. Dak.
Farley & Loetscher Manufacturing Co., Dubuque, Iowa
Feldman Wood Products Co., Inc., Long Island City, N. Y.
Flannagan, Eric G., & Sons, Henderson, N. C.
Flint Sash & Door Co., Inc., Flint, Mich.
General Millwork Corp., Utica, N. Y.
Gibson Door Co., Inc., Utica, N. Y.
Goshen Sash & Door Co., Goshen, Ind.
Grayson Millwork & Supply Co., Sherman, Tex.
Grogan Robinson Lumber Co., Great Falls, Mont.
H & S Lumber Co., Charlotte, N. C.
Hager & Cove Lumber Co., Lansing, Mich.
Harbor Sales Co., Inc., Baltimore, Md.
Hastings, A. W., & Co., Inc., Somerville, Mass.
High Sierra Pine Mills, Inc., Oroville, Calif.
Houston Sash & Door Co., Houston, Tex.
Hussey-Williams Co., Inc., Ozone Park, N. Y.
Huttig Sash & Door Co., St. Louis, Mo.; Atlanta, Ga.; Charlotte, N. C.; Columbus, Ohio; Dallas, Tex.; Jacksonville, Fla.; Knoxville, Tenn.; Louisville, Ky.; Miami, Fla.; Nashville, Tenn.; Roanoke, Va.
Hyde-Murphy Co., Ridgway, Pa.
Illinois Valley Manufacturing Co., Peru, Ill.
International Paper Co., Long-Bell Division, Kansas City, Mo.
Interstate Sash & Door Co., Canton, Ohio
Jacksonville Sash & Door Co., Inc., Jacksonville, Fla.
Kellogg, Chas. C., & Sons Co., Utica, N. Y.
Kemp, Bunch & Jackson, Jacksonville, Fla.

Keystone Frame & Manufacturing Co., Spokane, Wash.
Latenser, John, & Sons, Omaha, Nebr.
Law, Law, Potter & Nystrom, Madison, Wis.
Loeb, Laurence M., White Plains, N. Y.
Loetscher & Burch Manufacturing Co., Des Moines, Iowa
Los Angeles, City of, Department of Public Works, Bureau of Public Buildings, Los Angeles, Calif.
Lumbermen's Millwork & Supply Co., Ardmore, Okla.
Malta Manufacturing Co., Malta, Ohio
Mann & Co., Hutchinson, Kans.
Mason City Millwork Co., Mason City, Iowa
McGuinn, N. J., Lumber Co., Charlotte, N. C.
Memphis Sash & Door Co., Memphis, Tenn.
Merritt Lumber Yards, Inc., Reading, Pa.
Metler Bros., Klamath Falls, Oreg.
Miller Millwork Corp., Charlotte, N. C.
Miller, Vrydagh & Miller, Terre Haute, Ind.
Minot Builders Supply Co., Inc., Minot, N. Dak.
Missoula White Pine Sash Co., Missoula, Mont.
Mooser, William, San Francisco, Calif.
Morgan Sash & Door Co., Chicago, Ill.
Muhlenberg Bros., Wyomissing, Pa.
National Plywood Co., Inc., New York, N. Y.
Nebraska, University of, Mechanical Engineering Department, Lincoln, Nebr.
New Mexico Co., Albuquerque, N. Mex.
New York Central Railroad Co., New York, N. Y.
Northern Sash & Door Co., Hawkins, Wis.
Norwood Sash & Door Manufacturing Co., Cincinnati, Ohio
Nurenburg, W. S., Fort Worth, Tex.
O & N Lumber Co., Menomonie, Wis.
Palmetto Sash & Door Co., Inc., Orangeburg, S. C.
Patten-Blinn Lumber Co., Los Angeles, Calif.
Pease Woodwork Co., Inc., Hamilton, Ohio
Peterson, L. L., Enterprises, St. Paul, Minn.
Pittsburgh Testing Laboratory, Pittsburgh, Pa.
Portsmouth Lumber Corp., Portsmouth, Va.
Quigley, J. R., Co., Gloucester City, N. J.
Reints Sash & Door Co., Oklahoma City, Okla.
Resnikoff, Abraham, New York, N. Y.
Rinn Scott Lumber Co., Chicago, Ill.
Ritchie, James H., & Associates, Boston, Mass.
Roach & Musser Co., Muscatine, Iowa
Rock Island Millwork Co., Rock Island, Ill.
Rockwell of Randolph, Inc., Randolph, Wis.
Royal Oak Wholesale Co., Royal Oak, Mich.
Sanders Bros. Manufacturing Co., Ottawa, Ill.
Sanders Co., Baltimore, Md.
Sears, Roebuck & Co., Chicago, Ill.
Semling Menke Co., Inc., Merrill, Wis.
Shenk, Henry, Co., Erie, Pa.
Silcrest Co., Wausau, Wis.
Smith, Allen A., Co., Toledo, Ohio

Smith, Ralph L., Lumber Co., Anderson, Calif.
Snell Sash & Door Co., St. Paul, Minn., and Omaha, Nebr.
Sothman Co., Grand Island, Nebr.
Southwestern Sash & Door Co., Joplin, Mo.
Spokane Pine Products Co., Spokane, Wash.
Stevens, Frank, Sash & Door Co., Waco, Tex.
Stoetzel, Ralph, Chicago, Ill.
Stravs, Carl B., Minneapolis, Minn.
Swan Lake Moulding Co., Klamath Falls, Oreg.
Tarter, Webster & Johnson, Inc., San Francisco, Calif.
Texas Sash & Door Co., Fort Worth, Tex.
Throop-Martin Co., Columbus, Ohio
Trexler Lumber Co., Allentown, Pa.
Tulane Hardwood Lumber Co., Inc., New Orleans, La.
Vaughn Millwork Co., Reno, Nev.
Villaume Box & Lumber Co., St. Paul, Minn.
Vogel, Willis A., Toledo, Ohio
Wabash Screen Door Co., Chicago, Ill.
Walling Sash & Door Co., Wichita, Kans.
Washington Woodworking Co., Inc., Washington, D. C.
Welch, Carroll E., Huntington, N. Y.
Welch Sash & Door Co., Port Huron, Mich.
Western Door & Sash Co., Oakland, Calif.
Western Pine Manufacturing Co., Spokane, Wash.
Whissel, L. N., Lumber Co., Inc., Buffalo, N. Y.
White Pine Sash Co., Spokane, Wash.
Whittier Lumber & Millwork Co., Newark, N. J.
Wholesale Service Co., Inc., Louisville, Ky.
Wisconsin Window Unit Co., Merrill, Wis.
Wolverine Shingle & Lumber Co., Detroit, Mich.

U. S. GOVERNMENT AGENCIES

U. S. Forest Service, Missoula, Mont.
U. S. Naval Air Station, Anacostia, Washington, D. C.

OTHER COMMERCIAL STANDARDS

A list of all effective Commercial Standards may be obtained from the Commodity Standards Division, Office of Technical Services, U. S. Department of Commerce, Washington 25, D. C. These publications may be purchased at the prices indicated on the list, which also includes directions for ordering copies.

federal register

National Bureau of Standards

VOLUNTARY STANDARDS

Action on Proposed Withdrawal

In acordance with § 10.12 of the Department's "Procedures for the Development of Voluntary Product Standards" (15 CFR Part 10, as revised; 35 FR 8349 dated May 28, 1970), notice is hereby given of the withdrawal of the following Commercial Standards:

CS 120–58, "Ponderosa Pine Doors."
CS 163–64, "Ponderosa Pine Windows, Sash and Screens (Using Single Glass and Insulating Glass)"
CS 171–58, "Hardwood Veneered Doors (Solid-Core, Hollow-Core and Panel and Sash)"
CS 190–64, "Wood Double-Hung Window Units"
CS 204–64, "Wood Awning Window Units"
CS 205–64, "Wood Casement Window Units"
CS 208–57, "Standard Stock Exterior Wood Window and Door Frames"
CS 262–63, "Water-Repellent Preservative Non-Pressure Treatment for Millwork"
CS 264–64, "Wood Horizontal-Sliding Window Units (All Sash Operating)"
CS 265–64, "Wood Horizontal-Sliding Window Units (One or More Non-Operating Sash)"
CS 266–64, "Wood Single-Hung Window Units"

It has been determined that each of these standards has become technically inadequate, and in view of the existence of up-to-date National Woodwork Manufacturers Association standards for the products covered, revision of the Commercial Standards would serve no useful purpose.

This action is taken in furtherance of the Department's announced intentions as set forth in the public notice appearing in the FEDERAL REGISTER of March 27, 1974 (39 FR 11319), to withdraw these standards.

The effective date for the withdrawal of these standards will be 60 days after the publication of this notice. This withdrawal action terminates the authority to refer to these standards as voluntary standards developed under the Department of Commerce procedures.

Dated: May 30, 1974.

RICHARD W. ROBERTS,
Director.

[FR Doc.74–12838 Filed 6–4–74;8:45 am]